



4X  $\phi$  .406 THRU ALL  
 $\square$   $\phi$  .625  $\nabla$  1.40  
 $\phi$  0.010 B A C

NOTES :

1. THOROUGHLY CLEAN PART TO REMOVE ALL OIL, GREASE DIRT AND CHIPS.
2. ALL MACHINING FLUIDS MUST BE WATER SOLUBLE AND FREE OF SULFUR, CHLORINE, AND SILICONE, SUCH AS CINCINNATI MILACRON CIMTECH 410.
3. WHERE INDICATED, MECHANICALLY SCRIBE, STAMP OR ENGRAVE (VIBRATORY ACCEPTABLE) THE FOLLOWING INFORMATION AS SHOWN BELOW: PART-NUMBER REVISION, USE 0.12" TALL CHARACTERS UNLESS PART SIZE DICTATES SMALLER

		UNLESS OTHERWISE SPECIFIED:	NAME	DATE
		DIMENSIONS ARE IN INCHES	DRAWN	MATICHARD 8-13-07
		TOLERANCES	CHECKED	STEIN 8-14-07
		TWO PLACE DECIMAL : $\pm$ 0.015	ENG APPR.	MASON 8-16-07
		THREE PLACE DECIMAL : $\pm$ 0.005	MFG APPR.	
		ANGULAR: $\pm$ 30°	Q.A.	
		SURFACE FINISH: 125	COMMENTS:	
		INTERPRET GEOMETRIC TOLERANCING PER:		
		MATERIAL		
		6061 ALLOY		
NEXT ASSY	USED ON	FINISH		
APPLICATION		DO NOT SCALE DRAWING		

**LIGO MIT**

TITLE:  
**HAM Riser  
 Preloading Tool**

SIZE	DWG. NO.	REV
<b>A</b>	D070303-A-D	<b>A</b>
SCALE: 1/2	WEIGHT: 4 pds	SHEET 1 OF 1